

# Work Order ID 72524

Thursday, July 28, 2011 10:48:22 AM

Sept 1st



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Stop



Start Date: 7/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-07-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: 114514  
117884

0.00

Large Fab

Memo

0.00

Large Fab

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

11-09-28

1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



# Work Order ID 72524





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Item ID: D4055-041 Accept  Setup Start   
Revision ID:  
Item Name: Fuel Tank Assembly Stop   
Start Date: 7/28/2011 Start Qty: 1.00  Cust Item ID:  
Required Date: 8/22/2011 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				 11,097	28		
121  Large Fab Large-Fab	Weld per dwg A/R Aluminum rod Batch: 114514 117884  Memo 1-Weld top D4055-1	0.00  0.00		11-10-03		1	0		
122  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				1	0	BE 11/10/04	

W/O:			WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 28, 2011 10:48:22 AM



Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 7/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Small Fab

Small Fab

Memo

Assemble as per dwg

0.00

0.00

*Signature* 8/4/10/06 (1)

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*Signature*

(CC)

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*Signature*

W/O:		WORK ORDER CHANGES						
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**Work Order ID 72524**

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230



Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

0.00

Packaging

11/10/11

240



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/11

MF  
11-10-07

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B  
 10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23  
 revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055  
 revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1  Placard		Manufactured	No			190	Each	6.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>68930</div> <div>71177</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>2</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3997-5  Placard		Manufactured	No			190	Each	8.0000	2	2			
<div> <div>Location</div> <div>ST104</div> <div>71170</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3997-11  Placard		Manufactured	No			190	Each	5.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>65124</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3997-17  Placard		Manufactured	No			190	Each	5.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>65125</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B73509 SP

B72641 SP

B73510 SP

B73513 SP 11-10-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190

Each

5.0000

1

1



Placard



B72622 SP 11/06

Location

Loc Qty

Loc Code

ST104

5

65126

5

D3997-43

Manufactured No

190

Each

4.0000

1

1



Placard



B 72629 11 SP 11-10-06

Location

Loc Qty

Loc Code

ST104

4

65127

4

✓ D3999-7

Manufactured No

100

Each

1.0000

1

1



Corner



11.10.03

Location

Loc Qty

Loc Code

ENG

B71695

1

55645

1

✓ D3999-9

Manufactured No

100

Each

0.0000

1

1



Angle



11.09.17

372441 = 1

✓ D3999-11

Manufactured No

100

Each

0.0000

1

1



Earth Tab



11.10.03 B71694

✓ D3999-041

Manufactured No

100

Each

2.0000

1

1



Baffle Assembly, Aft



11.09.17

Location

Loc Qty

Loc Code

WA014

B72653

2

70248

2

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Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3999-043 Manufactured No 100 Each 2.0000 1 1  
Baffle Assembly, Fwd  
11.09.17

Location Loc Qty Loc Code  
WA014 B71493 2  
70249 2

✓ D4000-1 Manufactured No 100 Each 6.0000 1 1  
Fuel Supply Fitting  
11.10.03

Location Loc Qty Loc Code  
WA 4  
71896 4  
WA013 2  
65716 2

✓ D4000-5 Manufactured No 100 Each 6.0000 1 1  
Fuel Tank Vent Fitting  
11.09.24

Location Loc Qty Loc Code  
WA013 6  
72427 6

✓ D4000-9 Manufactured No 100 Each 10.0000 3 3  
Grommet  
11.09.23

Location Loc Qty Loc Code  
WA013 B73646 10  
70250 10

✓ D4000-043 Manufactured No 100 Each 0.0000 1 1  
Drain Fitting Assembly, Fwd  
11.09.17

B72085 = 1

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Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, July 28, 2011 10:48:29 AM

Page 4

Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-045

Manufactured No

100

Each

3.0000

1

1



Fuel Pickup Fitting Assembly

B72078

Location

Loc Qty

Loc Code

WA

3

71669

3

Manufactured No

100

Each

0.0000

1

1

✓ D4000-041



Drain Fitting Assembly, Aft

B72084 = 1

✓ D4001-1

Manufactured No

100

Each

1.0000

1

1



Fitting

~~B72084~~ = 1  
B71698

Location

Loc Qty

Loc Code

WA013

1

66840

1

Manufactured No

100

Each

7.0000

1

1

✓ D4008-11



Hinge Half

Location

Loc Qty

Loc Code

ST108

7

65445

3

67650

4

Manufactured No

190

Each

5.0000

1

1

D4008-041



Fuel Filler Splash Guard Assembly

Location

Loc Qty

Loc Code

ST108

5

72200

5

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4023-3

Manufactured No

100

Each

8.0000

1

1



Cap and Flange

Location

Loc Qty

Loc Code

ST110

4

72243

4

WA

4

70204

4

D4025-1

Manufactured No

100

Each

3.0000

1

1



Fuel Quantity Sender

Location

Loc Qty

Loc Code

ST142

3

69502

3

✓ D4055-11

Manufactured No

100

Each

8.0000

1

1



Tank Front and Bottom

Location

Loc Qty

Loc Code

WA

B72249

3

70201

3

WA013

5

65447

2

68500

3

✓ D4055-9

Manufactured No

100

Each

3.0000

1

1



Tank Back

Location

Loc Qty

Loc Code

WA013

B72251

3

63948

1

65451

1

66842

1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72524

Parent Item: D4055-041


Parent Item Name: Fuel Tank Assembly


Start Date: 7/28/2011

Required Date: 8/22/2011


Start Qty: 1.00


Required Qty: 1.00

✓ D4055-7 Manufactured No 100 Each 2.0000  
  
 Tank Fwd End


 1 1  
*11.09.28*


Location	Loc Qty	Loc Code
WA014 <u>371700</u>	2	
65450	1	
70251	1	

✓ D4055-5 Manufactured No 100 Each 3.0000  
  
 Tank Upper Cut Out


 1 1  
*11.09.24*


Location	Loc Qty	Loc Code
WA013 <u>372250</u>	3	
67737	3	

✓ D4055-3 Manufactured No 100 Each 2.0000  
  
 Tank Aft End

 1 1  
*11.10.03*

Location	Loc Qty	Loc Code
WA <u>371699</u>	1	
68501	1	
WA014	1	
70447	1	

✓ D4055-1 Manufactured No 100 Each 1.0000  
  
 Tank Top

 1 1  
*11.09.24*

Location	Loc Qty	Loc Code
WA013 <u>371701</u>	1	
65446	1	

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W/O:		WORK ORDER CHANGES						
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Work Order ID: 72524

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/28/2011

Required Date: 8/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4057-1 Manufactured No

100 Each

44.0000

3

3



Retaining Ring



11-09-17

Location

Loc Qty

Loc Code

WA013

44

55826

8

71166

36

AN3H5A

Purchased

No

190

Each

57.0000

5

5



Bolt



3

Location

Loc Qty

Loc Code

ST350

7

116704

7

ST351

50

118112

50

NAS1149D0363J

Purchased

No

190

Each

2,736.000

5

5



Washer



5X

Location

Loc Qty

Loc Code

ST298

2736

117505

366

117601

370

118077

2000

D4404-1

Manufactured

No

190

Each

6.0000

1

1



Cushion



5X

Location

Loc Qty

Loc Code

ST404

6

70247

6

1X

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W/O:			WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

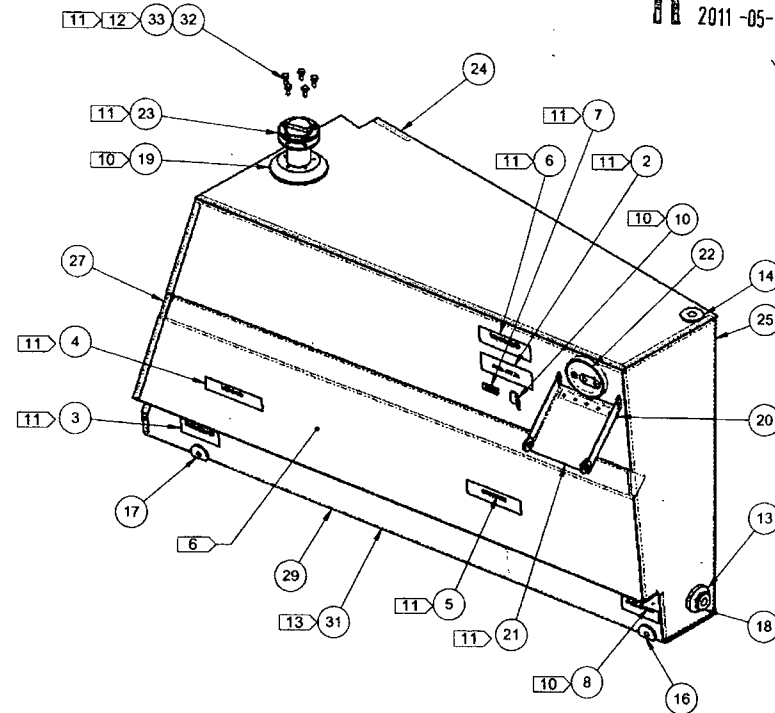
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 12524  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY

2011-07-20

RELEASED  
2011-05-30



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY

B	MOVE CAP POSITION AND CHANGE CAP DESIGN. ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	11.05.12
A	NEW ISSUE	HS 10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.05.12	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B SHEET 1 OF 15
TITLE TANK	SCALE NTS
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

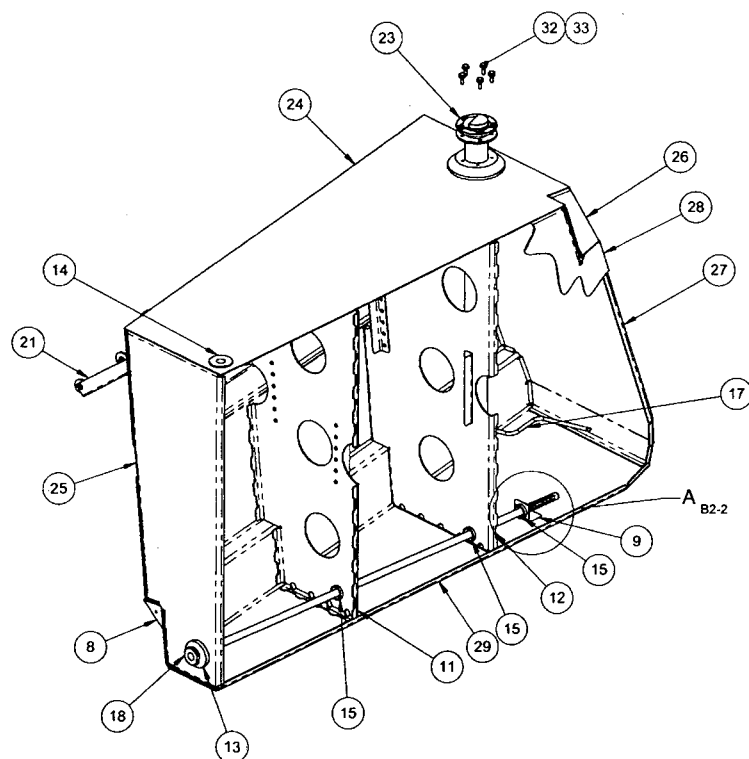
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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

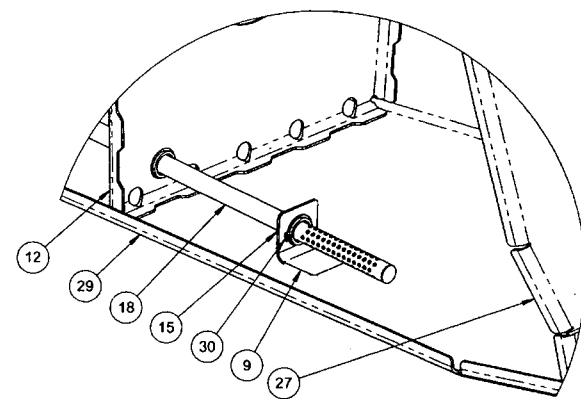
**NOTE:** Date & initial all entries

RELEASED  
2011-05-30  
JND

72524



**D4055-041 FUEL TANK ASSEMBLY**  
**D4055-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**



**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-2

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 2 OF 15
APPROVED		TITLE	SCALE
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DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

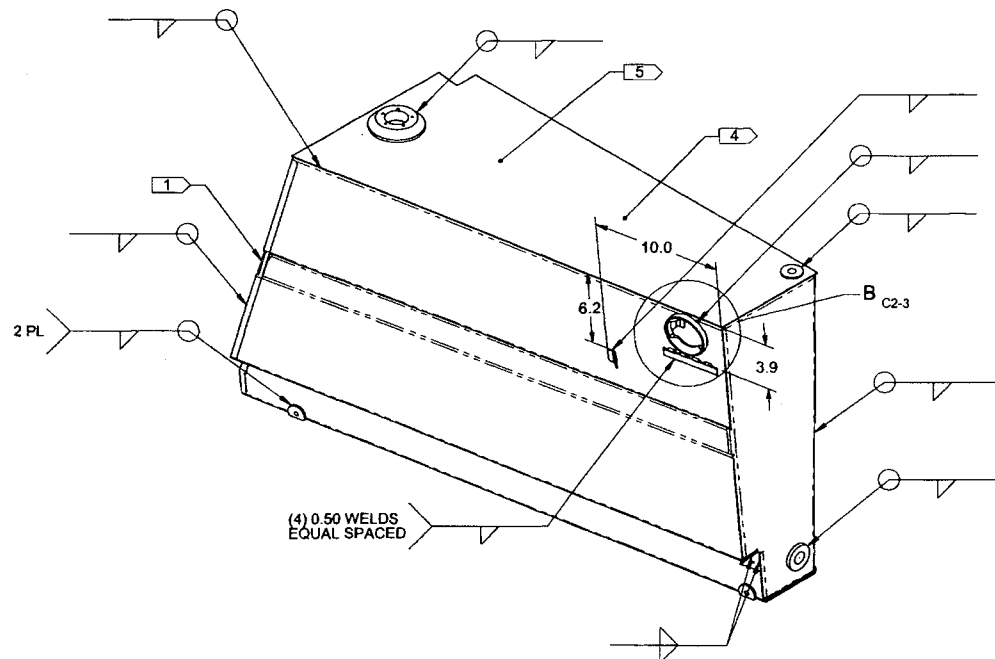
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

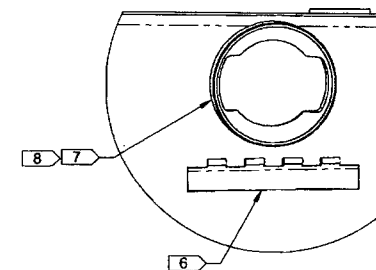
**NOTE:** Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**

**NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.80 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
  - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN. ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK



**DETAIL B  
ROTATED FOR CLARITY  
SCALE 2X**

C4-3

**RELEASED**  
2011-05-30

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 3 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

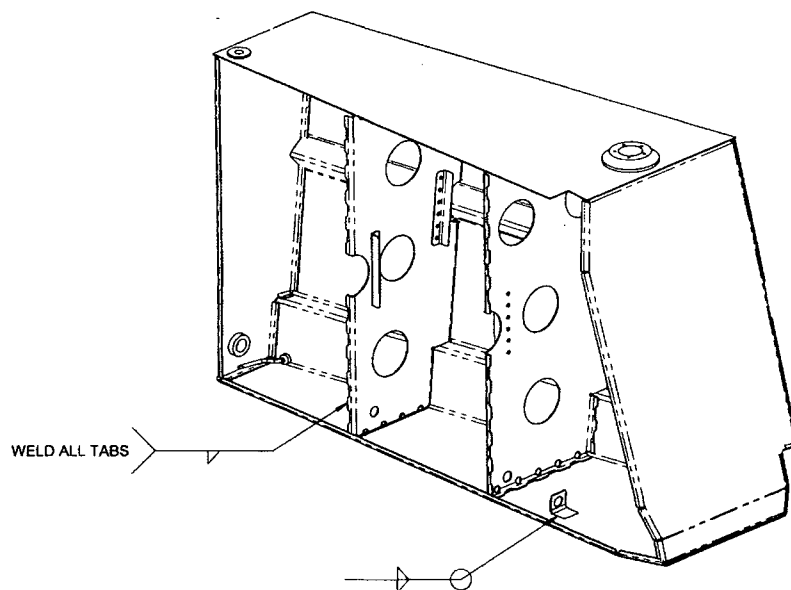
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

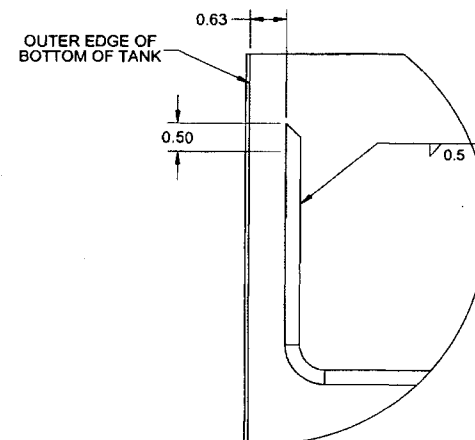
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4055-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**



**DRAIN TUBE INSTALLATION - TYP  
VIEWED FROM ABOVE  
FWD END SHOWN, AFT END OPPOSITE**

**RELEASED**  
2011-05-30  
JW

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 4 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

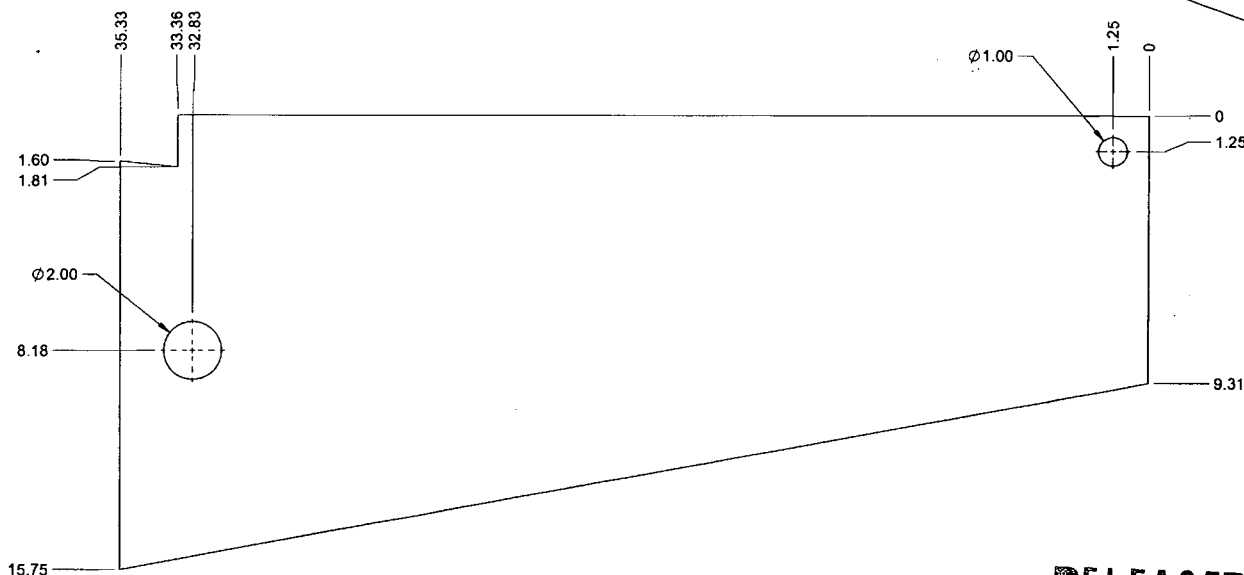
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

72524



**D4055-1 TANK TOP**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs



**RELEASED**  
2011-05-30  
JH

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D4055	SHEET 5 OF 15
APPROVED		TITLE	SCALE
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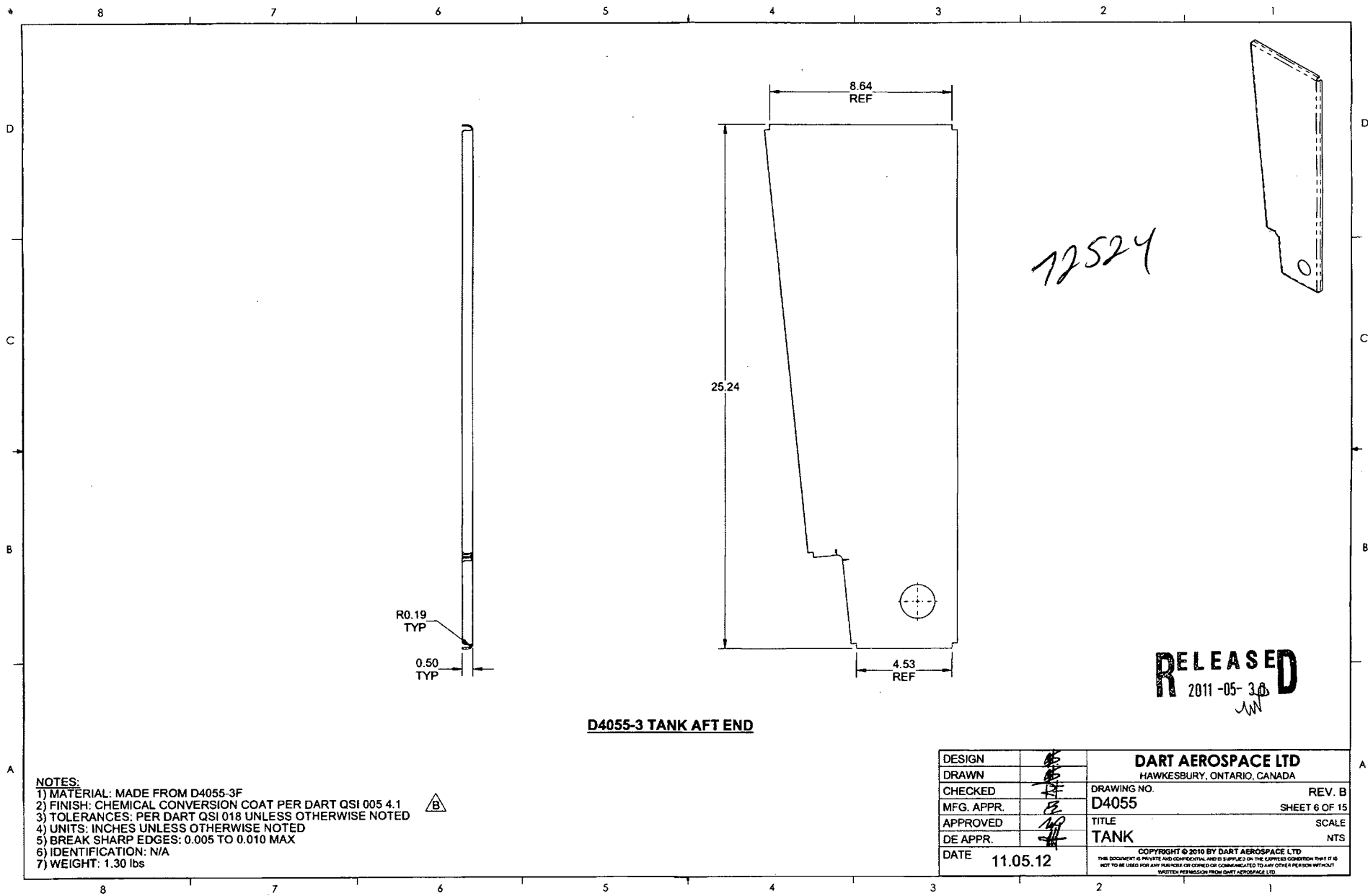
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.30 lbs



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

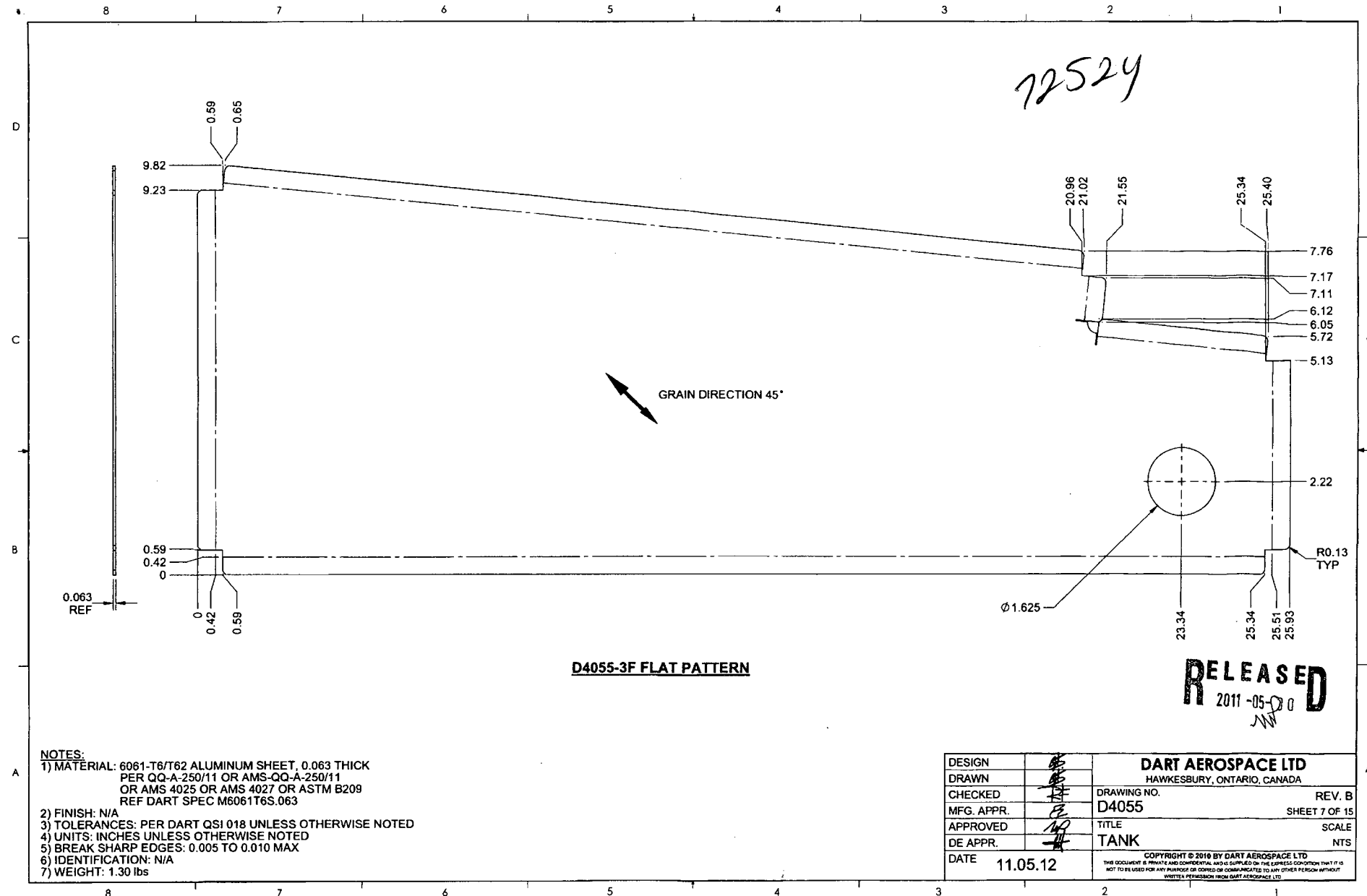
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

72524



**D4055-3F FLAT PATTERN**

**RELEASED**  
2011-05-20  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4055	SHEET 7 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

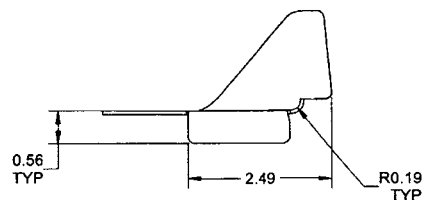
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

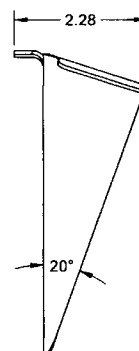
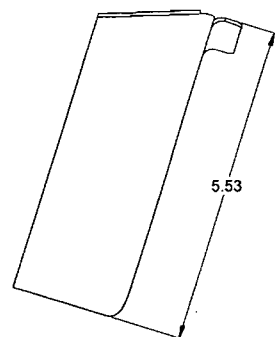
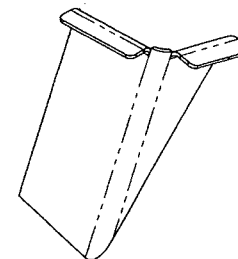
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





72524



# **D4055-5 UPPER CUT OUT**

**RELEASED**  
2011-05-30  
ANN

## **NOTES:**

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4055</b>	SHEET 8 OF 15
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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

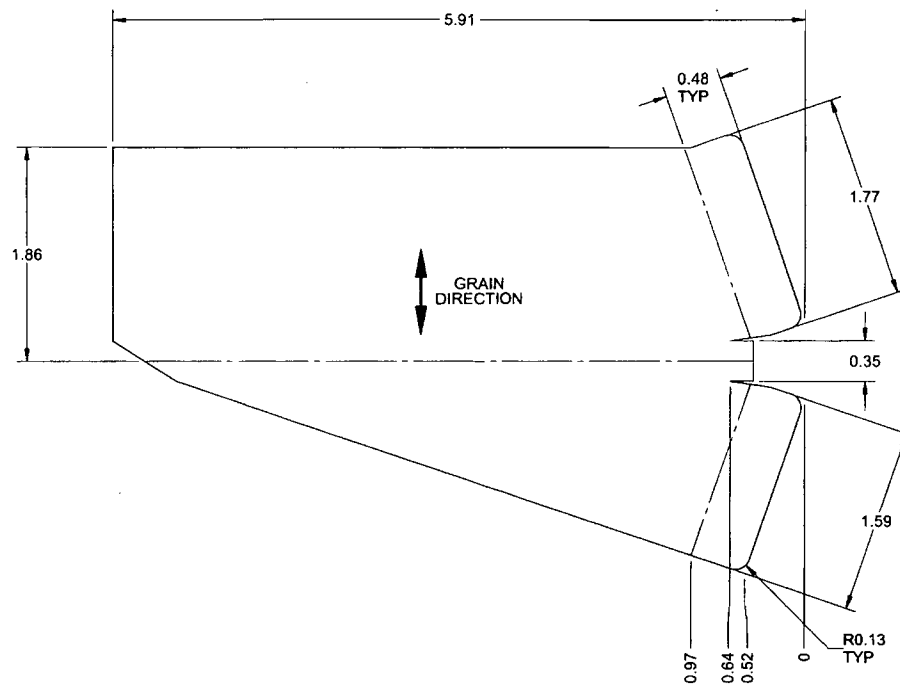
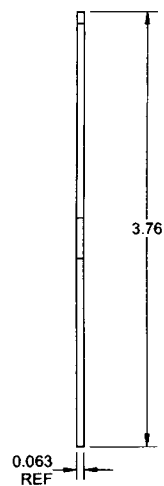
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

12824



**D4055-5F FLAT PATTERN**

**RELEASED**  
2011-05-30

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 9 OF 15
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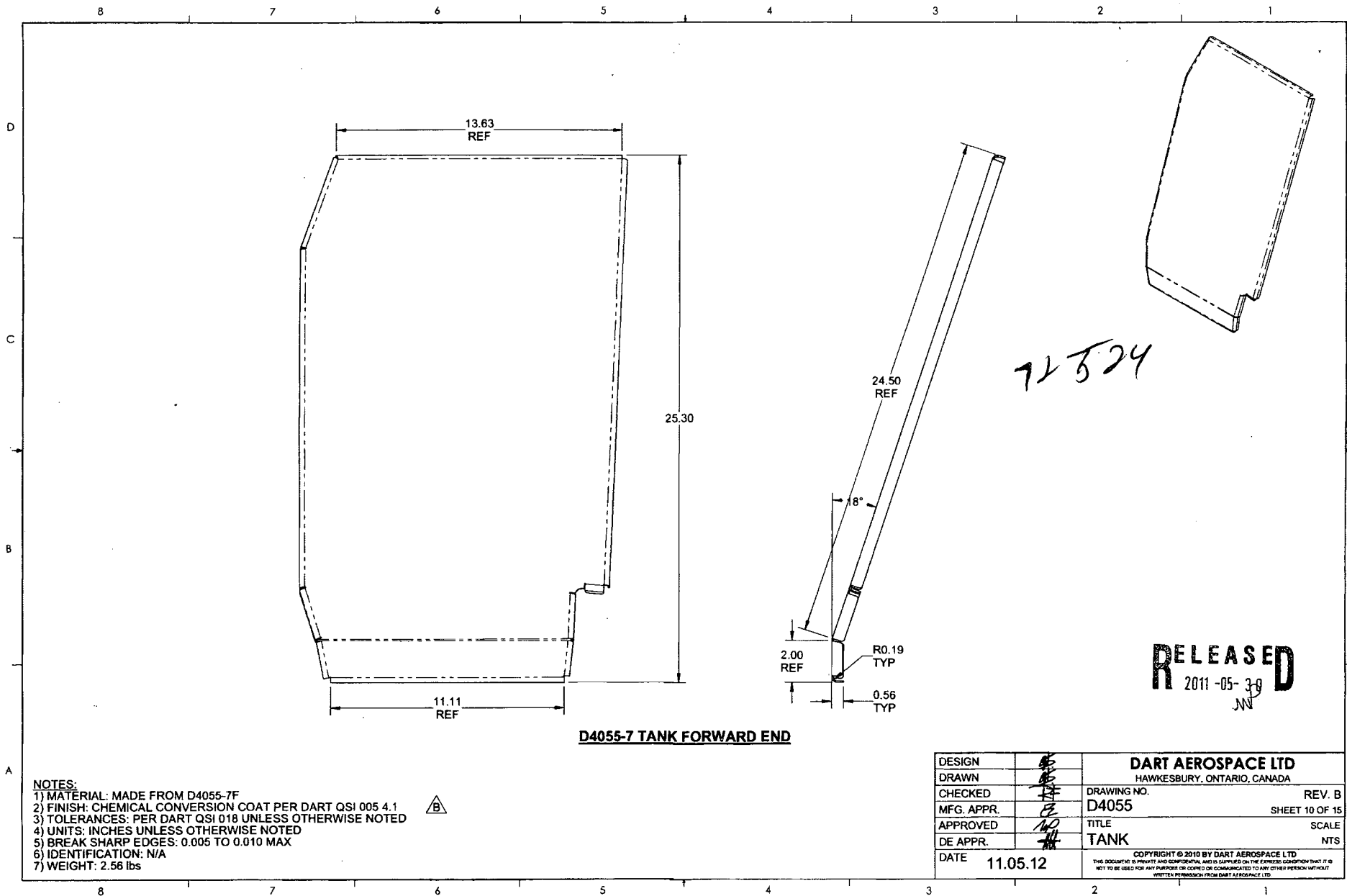
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

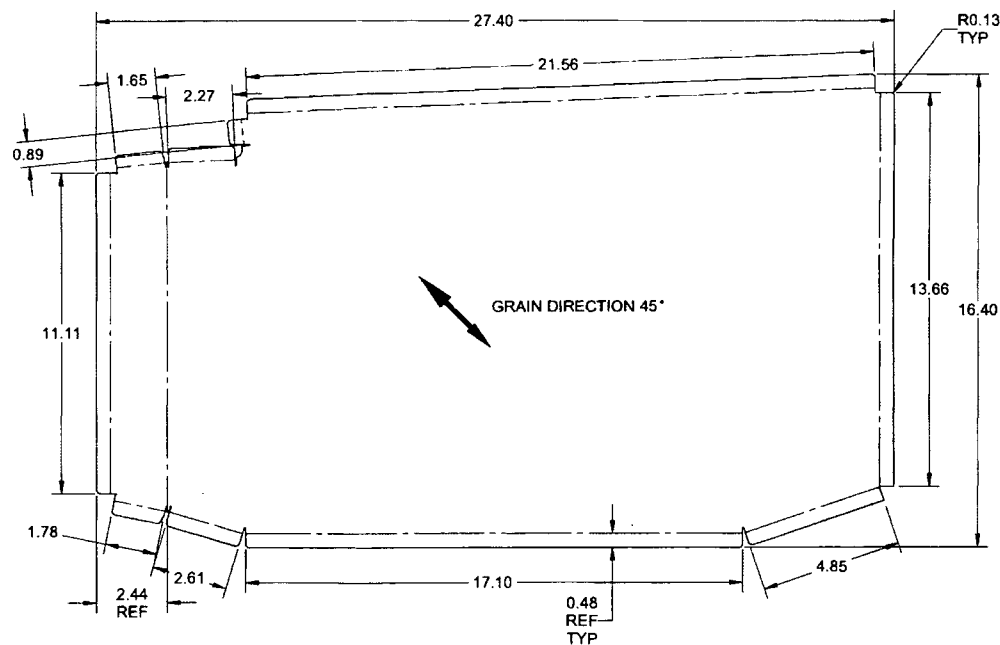
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

0.063  
REF



**D4055-7F FLAT PATTERN**

**RELEASED**  
2011-05-30  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

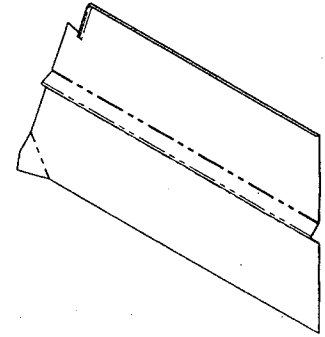
**NOTE:** Date & initial all entries



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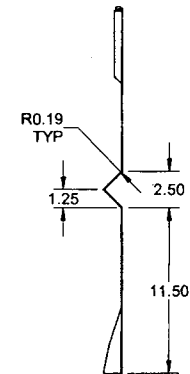
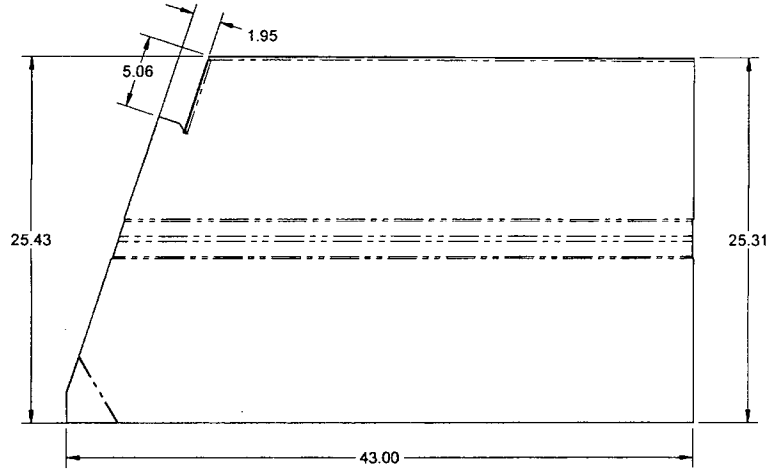
D

D



C

C



12524

B

B

**D4055-9 TANK BACK**

**RELEASED**  
2011-05-30  
JAN

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

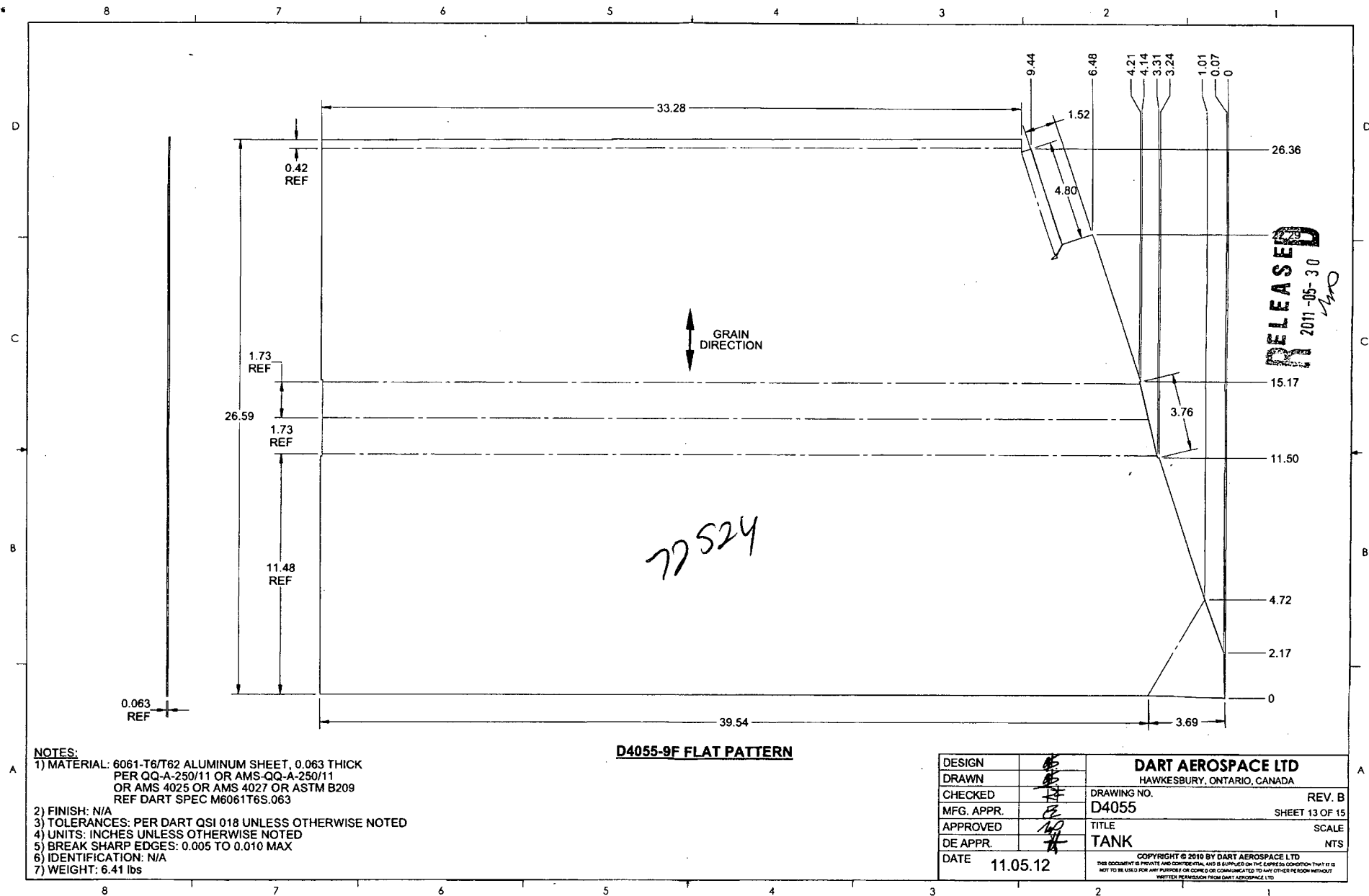
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			







NOTE: Date & initial all entries



# NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

## **D4055-9F FLAT PATTERN**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 13 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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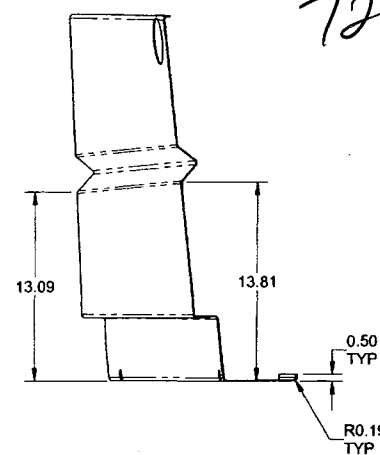
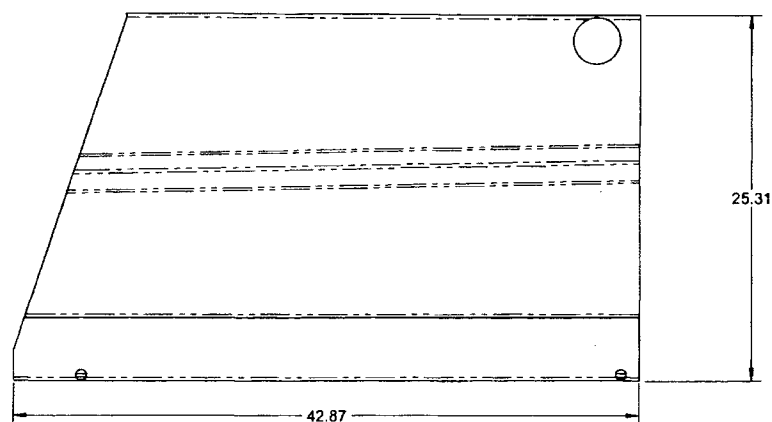
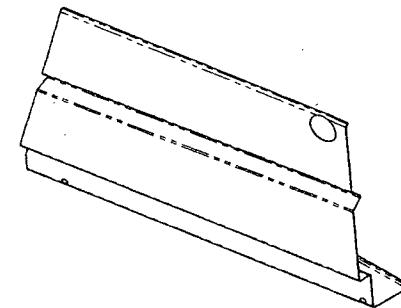
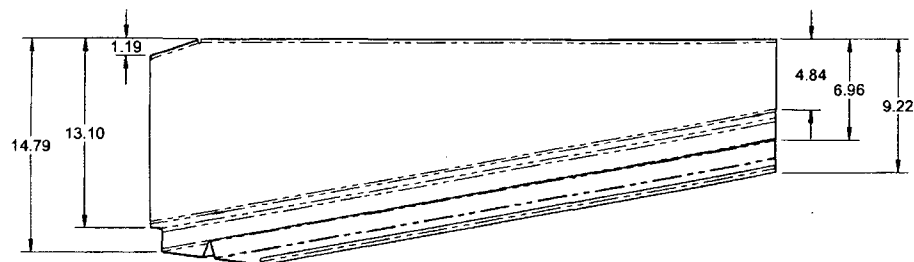
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









72524

**D4055-11 TANK FRONT AND BOTTOM**

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
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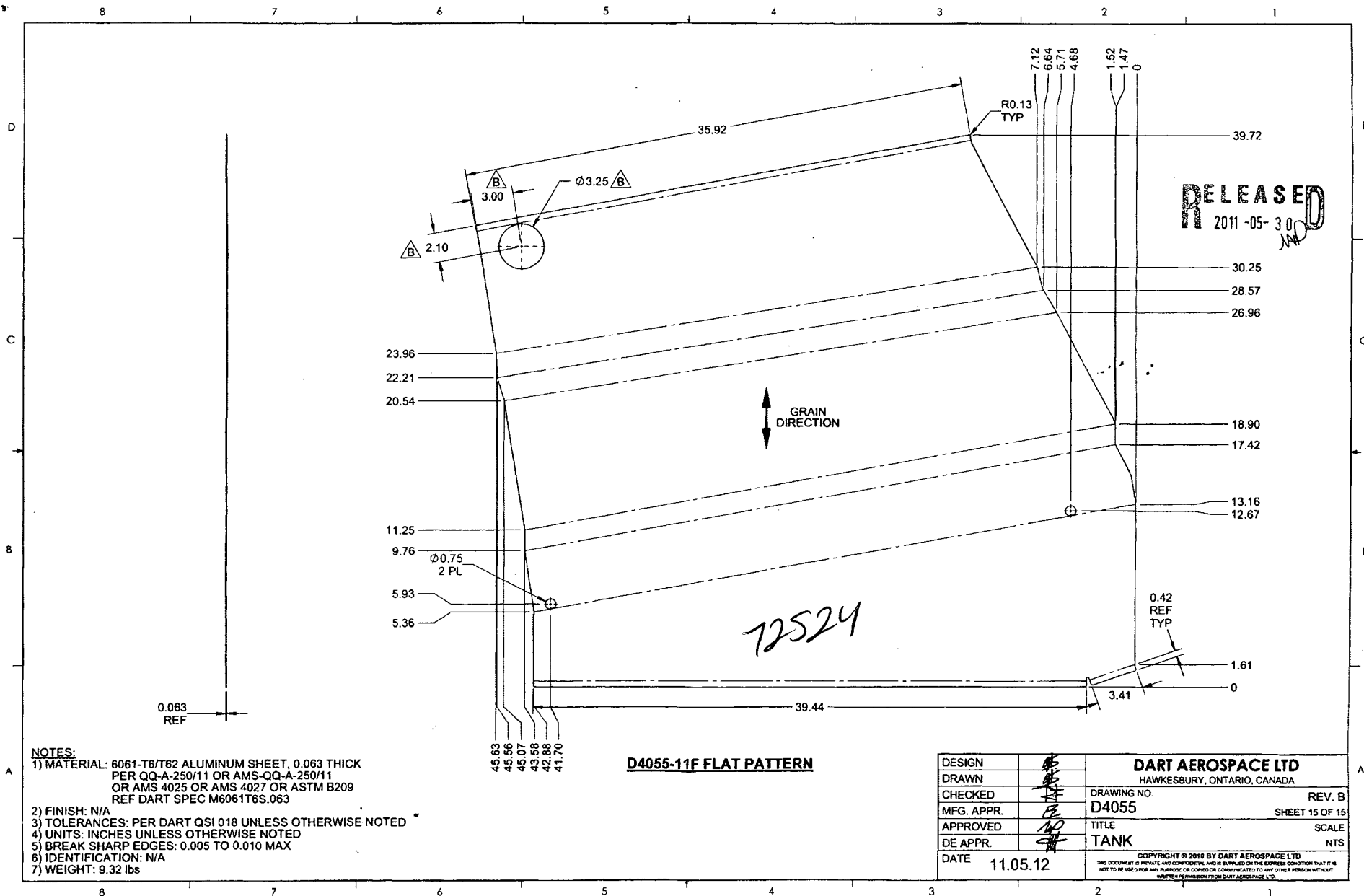
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries